

Work Order ID 81470

81470

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March-14-12 12:59:17 PM

Item ID: D3907-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 14/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 21/03/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 12/03/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3907	A								

100 0.00
100
 Hardinge *Sh rebar* 40 φ
 Hardinge CNC Lathe Small
 Memo
 Machine as per Folio FA823
 & Dwg D3907
 Dwg Rev: A
 folio Rev: AA
 Deburr

110 0.00
110
 QC *Sh 12/03/12* 40 φ
 Quality Control
 Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	12/03/21		40	0		
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>Wp</u> Memo *****STOCK IN BASKET CELL*****	0.00 0.00							12/3/22 sf (40)
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/3/26 JF ME 12-03-23

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Picklist Print

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Parent Item: D3907-1

D3907-1

Parent Item Name: Bushing

Start Date: 14/03/2012

Required Date: 21/03/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	20.0310	0.03	1.2			

M304R0 375

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT029

20.031

119346

1.564

120204

18.467

1.5

12/03/12

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	10.06.07	Tolerance for dimension Ø0.375 revised	KJ 	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

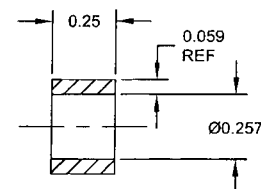
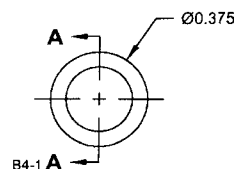
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81470 MCL
12/03/14



D3907-1 BUSHING

SECTION A-A CS-1

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
9/16/14

A	NEW ISSUE	AJS	09.03.11
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3907	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING (BASKET REPAIR)	NTS
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONTAINED OR CONTAINED IN ANY OTHER PERSON, OR ANY OTHER PERSON'S DOCUMENT, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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